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IS 8692-3 (2007): Cylindrical shanks for milling cutters,
Part 3: Dimensional characteristics of threaded shanks [PGD
32: Cutting tools]

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Indian Standard

CYLINDRICAL SHANKS FOR MILLING CUTTERS

PART 3 DIMENSIONAL CHARACTERISTICS OF THREADED SHANKS

ICS 25.100.20

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BUREAU OF INDIAN STANDARDS
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NATIONAL FOREWORD

This Indian Standard (Part 3) which is identical with ISO 3338-3 : 1996 'Cylindrical shanks for milling cutters — Part 3: Dimensional characteristics of threaded shanks' issued by the International Organization for Standardization (ISO) was adopted by the Bureau of Indian Standards on the recommendation of the Milling Cutters, Saws, Gear Cutting Tools and Broaches Sectional Committee and approval of the Production and General Engineering Division Council.

This standard was first published in 1978 based on ISO 3338-1 : 1977 and ISO 3338-2 : 1977. In order to align with the latest version of ISO Standards, the revision of this standard was taken up and the standard was revised splitting into two parts. Subsequently, the need was felt to adopt third part of ISO 3338-3 : 1996. With the adoption of the third part of ISO 3338, the standard has been splitted into three parts:

Part 1 Dimensional characteristics of plain cylindrical shanks

Part 2 Dimensional characteristics of flattened cylindrical shanks

Part 3 Dimensional characteristics of threaded shanks

The text of ISO Standard has been approved as suitable for publication as an Indian Standard without deviations. Certain conventions are, however, not identical to those used in Indian Standards. Attention is particularly drawn to the following:

- a) Wherever the words 'International Standard' appear referring to this standard, they should be read as 'Indian Standard'.
- b) Comma (,) has been used as a decimal marker in the International Standards, while in Indian Standards, the current practice is to use a point (.) as the decimal marker.

The technical committee responsible for the preparation of this standard has reviewed the provisions of the following International Standards referred in this adopted standard and has decided that they are acceptable for use in conjunction with this standard:

<i>International Standard</i>	<i>Title</i>
ISO 228-1 : 1994 ¹⁾	Pipe threads where pressure-tight joints are not made on the threads — Part 1: Dimensions tolerances and designation
ISO 866 : 1975	Centre drills for centre holes without protecting chamfers — Type A
ISO 2540 : 1973	Centre drills for centre holes with protecting chamfers — Type B

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 1960 'Rules for rounding off numerical values (revised)'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

¹⁾ Since revised as ISO 228-1: 2000.

Indian Standard

CYLINDRICAL SHANKS FOR MILLING CUTTERS

PART 3 DIMENSIONAL CHARACTERISTICS OF THREADED SHANKS

1 Scope

This part of ISO 3338 specifies the dimensions of threaded shanks for milling cutters (of diameters 6 mm to 32 mm).

The dimensions of plain and flattened cylindrical shanks are the subject of ISO 3338-1 and ISO 3338-2 respectively.

2 Normative references

The following standards contain provisions which, through reference in this text, constitute provisions of this part of ISO 3338. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this part of ISO 3338 are encouraged to investigate the possibility of applying the most recent editions of the standards indicated below. Members of IEC and ISO maintain registers of currently valid International Standards.

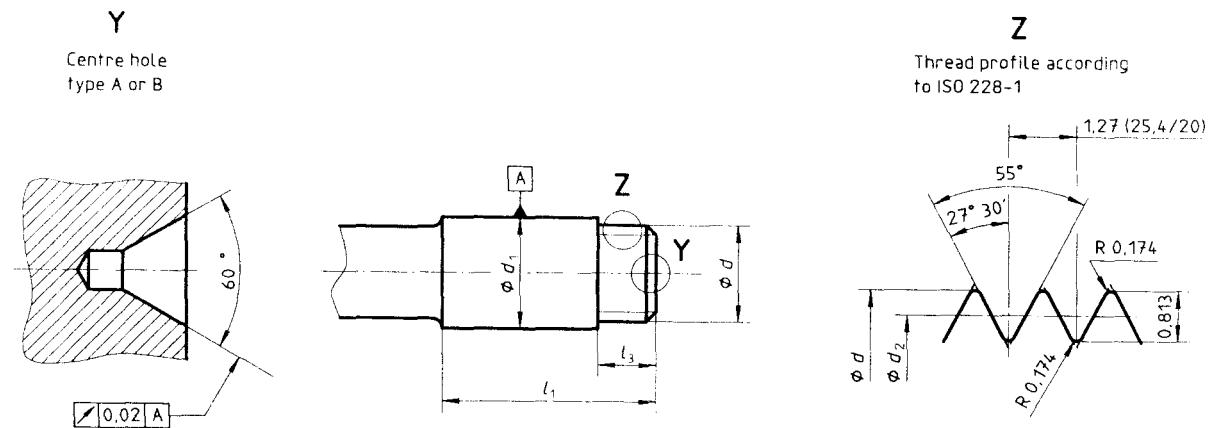
ISO 228-1:1994, *Pipe threads where pressure-tight joints are not made on the threads — Part 1: Dimensions, tolerances and designation*.

ISO 866:1975, *Centre drills for centre holes without protecting chamfers — Type A*.

ISO 2540:1973, *Centre drills for centre holes with protecting chamfer — Type B*.

3 Dimensions

See figure 1 and table 1.



NOTE — The run-out tolerance between the centre hole and the shank axis is intended to ensure a correct centring of the end mill into the chuck, subject to having a chuck with the appropriate precision. This chuck is not standardized.

Figure 1

Table 1

Dimensions in millimetres

d_1 h8	d	d_2	l_1 +2 0	l_3 +2 0	Centre hole ¹⁾
6 ²⁾	5,9	0 - 0,1	36	10	A 1,6/4 ³⁾ or B 1,6/6,3
10	9,9		40		
12 ²⁾	11,9		45		
16	15,9		48		
20	19,9	0 - 0,15	50	15	A 2,5/6,3 or B 2,5/10
25	24,9		56		
32 ²⁾	31,9		60		

1) According to ISO 866 or ISO 2540.

2) Not in conformity with ISO 237:1975, *Rotating tools with parallel shanks — Diameters of shanks and sizes of driving squares*.

3) For the shank diameter of 6 mm, the length of the centre hole of Ø 1,6 mm shall be limited in order to obtain a diameter of the cone equal to 2,5 mm (instead of 3,35 mm in ISO 866).

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Amendments Issued Since Publication

Amend No.	Date of Issue	Text Affected

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